



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBD29826-3
Job Sheet 181023



Part No: RBD29826-3

Job Qty: 25 ea

Part Name: Torque Wrench Adapter 4-Blade



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/19/18

Job Tracking No:

Due Date: 8/1/18

Created By: Linda Lacelle

Type: SOLD

Description:

Ship Via: DW 6 RBD29826

Rev 2.

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	25 Ea	8/1/18	8/1/18	0.00	0.00	Start Up Waterjet2		18/07/20
100	Waterjet	25 pcs	8/1/18	8/1/18	0.25	4.17	Waterjet 2 OMAX		18/07/20
110	QC	25 pcs	8/1/18	8/1/18	0.00	0.00	QC2 Waterjet-4		18/07/20
120	Lathe Conv	25 pcs	8/1/18	8/1/18	0.50	4.17	Lathe Conv-2		
130	QC	25 pcs	8/1/18	8/1/18	0.00	0.00	QC2 Machining-5		
140	Mill Conv	25 pcs	8/1/18	8/1/18	0.50	3.13	Mill Conv 2		
150	QC	25 pcs	8/1/18	8/1/18	0.00	0.00	QC2 Machining-5		
160	QC	25 pcs	8/1/18	8/1/18	0.00	0.00	QC8 Machining-5		
170	Small Fab	25 pcs	8/1/18	8/1/18	0.00	0.00	Small Fab-9		
180	QC	25 pcs	8/1/18	8/1/18	0.00	0.00	QC5		
190	Packaging	25 pcs	8/1/18	8/1/18	0.00	0.00	Packaging3-2		
200	QC21-SA	25 Ea	8/1/18	8/1/18	0.00	0.00	QC21		

Part Op 170 - Engrave
Descriptions: 190 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140P0.375	TBD	1.0850 (.0434 ea)	90-Start up Operation	5069135

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4140P0.375	1	0	0

MT-4140-S-0.375

cx JUL 19 2018

Part Specifications

Specifications could not be found.

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



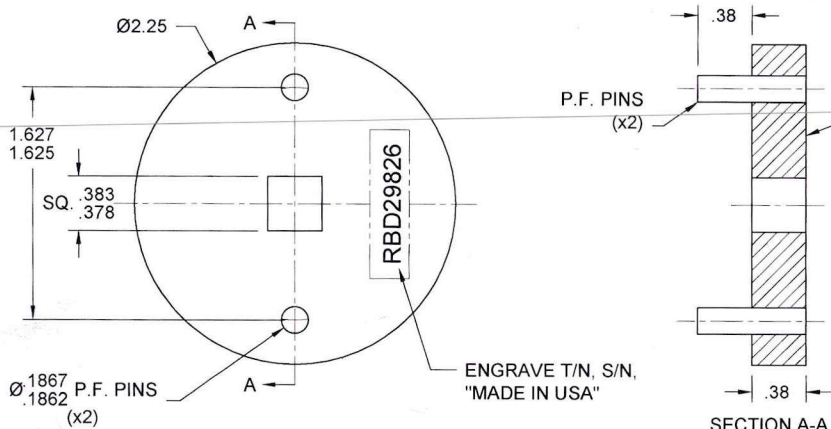
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	REDRAWN FROM 1980 DILAPIDATED PRINTS.	4/10/08	WP RW
2	ADDED -1 HEAT TREAT 28-32 RC AND CH'D MATERIAL FROM STRESS PROOF, CH'D ENGRAVE NOTE.	8/2/12	RJC SE



BSC ADAPTER

ASSY QTY	ASSY #	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
			-3	1	ADAPTER	4140	3/8 X 2-1/2 X 2-1/2
		B/O		2	DOWEL PINS	HARDENED STEEL	Ø .187 x 3/4
ASSY #							

RED BARN MACHINE	
TITLE: TORQUE WRENCH ADAPTER ASSEMBLY; FOUR BLADED TAIL ROTOR ASSY.	
DWG NO. RBD29826	REV 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS XXX ± .005 FRACTIONS ± 1/32 XX ± .01 ANGLES ± 5° X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR 015 R 2. DIMENSIONAL UNITS APPLY AFTER PLATING	
SCALE NTS	DATE 4-10-08
SHEET 1 of 1	
DRAWN BY: PERRITT APPROVED: <i>D Med</i> HEAT TREAT: 28-32 RC FINISH: BLACK OXIDE SPEC: MD USED ON MODEL	

WORK ORDER NON-CONFORMANCE / UPDATE



QA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>181023</u> Part No. <u>RBD29826 Rev. 2</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐		AGAINST DEPARTMENT/PROCESS Cross tube ☐ Water Jet ☐ Engineering ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Composite ☐ Supplier ☐			
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval July 31, 2018			
Description Work Order Deviation				Disposition					
RBD29826-3 can be manufactured from 303, 304, 316, 17-4PH-H900/H925/H1025/H1075/H1150 as an alternative material. The dowel pins must be replaced with McMaster Carr 98380A508 or equivalent. Finishing with Black Oxide is not required if the part is manufactured from Stainless Steel				- This deviation is acceptable. - The fit, form and function of the part will be as originally intended.					
								Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☒ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ ☒ Past Due		FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐							
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